

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029519**Date Inspected:** 08-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**In Process Visual Inspection**

RWR201304-011

Electroslag Weld (ESW) E-043, "Q"-Face A

The QA Inspector randomly observed ABF/JV welder Chris Bruce (WID-8901) performing weld repairs of a repair excavation on Electroslag Weld (ESW) "Q", at face A. Location of excavation of repair was:

Y= (Original) 5475mm

L= 770mm

W= 50mm

D= 60mm

The original defect designated for repair was listed in Request for Weld Repair (RWR) 201304-011. The welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with dual heat induction blankets at Face A. The welder utilized ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bernie Docena throughout the day and appeared to be in compliance with the WPS noted above. The welding repair at this location is still in process.

**In Process Visual Inspection**

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## WELDING INSPECTION REPORT

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RWR201304-012

Electroslag Weld (ESW) E-043, "Q"-Face B

The QA Inspector randomly observed ABF/JV welder Mike Jimenez (WID-4671) performing weld repairs on a repair excavation on Electroslag Weld (ESW) "N", at face B, original Y- location 6335mm. Location of rejectable indication is listed as detailed in Request for Weld Repair (RWR) 201304-012. The QA Inspector observed that preheat was being applied to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was observed checking the temperature with a 300° F. Tempilstick temperature indicator that melted on contact with the surface. The welder utilized ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for SMAW. The welding parameters were verified by QC Inspector Bernie Docena throughout the day and appeared to be in compliance with the WPS noted above. The welding repair on Face "B" was completed on this shift and still will undergo additional grinding. The repair area will be inspected with UT/MT after the required cooling time of 48 hrs as described in section 12 AWS D1.5-02.

### Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Adame,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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